

Need by March 1

Work Order ID 141968

141968

February 23, 2016 10:24:59 AM

Page 1

Item ID: PB67-43001-189

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: D-Pad Face

Start Date: 2/23/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/1/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: SK

Date: 20160222 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut to lenght (2.50")as per dwg

2- cut tube in half as per dwg

3- deburr

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

Cancelled
2/16/2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Page 2

February 23, 2016 10:24:59 AM

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐		Temperature/Cure ☐	Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐	Bending ☐		Set-up ☐	Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐		BOM/Route ☐	Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐	Cracks ☐		Broken/Damage/Defect ☐	Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐	Cuffs ☐		Contamination ☐	Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐	Crushing ☐		Countersink ☐	Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐		Cut Too Short ☐	Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐	Marks/Chatter ☐		Drill Holes ☐	Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐		Past Due ☐							

Picklist Print

February 23, 2016 10:24:59 AM

Work Order ID: 141968

141968

Parent Item: PB67-43001-189

PB67-43001-189

Parent Item Name: D-Pad Face

Start Date: 2/23/2016

Required Date: 3/1/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A new issue 08.06.19 EC verified: DD
IPP Rev:B 08-06-24 procedure chg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2914-142		Manufactured	No			100	Each	51.7300	0.01	1			

D2914-142

3" Outer Tube

Location

Loc Qty

Loc Code

Mezz

51.73

14092

51.73

DQA: _____ Date: _____

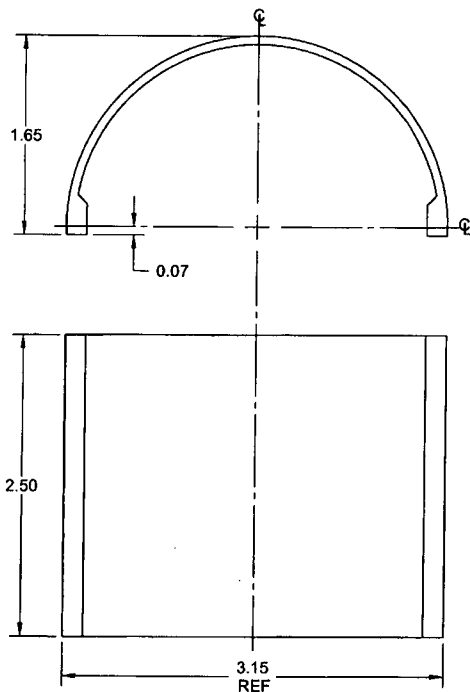


WORK ORDER NON-CONFORMANCE / UPDATE

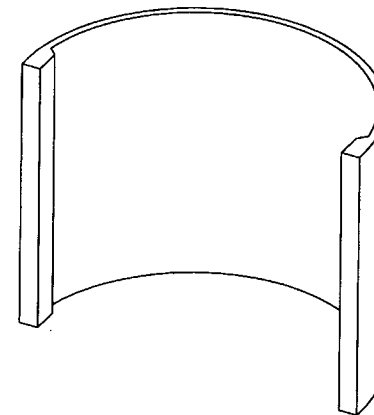
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																



B67-43001-189 D-PAD FACE



RELEASED
R 2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 25 OF PREMIER AVIATION DRAWING No. B67-43001. PART MANUFACTURED FROM D2914 EXTRUSION RATHER THAN SHEET METAL. REASON: SEE PART 09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	AJS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-189	SHEET 1 OF 1	
APPROVED	MM	TITLE	SCALE	
DE APPR.	N/A	D-PAD FACE	NTS	
DATE	09.02.24		COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: 6061-T6 PER QQ-A-200/8
REF. DART SPEC. D2914-142
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DART AEROSPACE LTD	Work Order:	141968
Description: D-Pad Face	Part Number:	PB67-43001-89
Inspection Dwg: B67-43001 Rev: C		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	